



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-1

Job Sheet 176792



Part No: D4776-1

Job Qty: 10 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/1/18

Job Tracking No:

Due Date: 5/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	5/18/18	5/18/18	0.00	0.00	Start Up Machining-3		
100	Doosan	10 pcs	5/18/18	5/18/18	0.54	5.32	Doosan		
105	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC2 Machining-3		
111	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC8 Machining-3		
112	HandFinish	10 pcs	5/18/18	5/18/18	0.00	0.29	HandFinish1		
113	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC7-4		
115	Powdercoat	10 pcs	5/18/18	5/18/18	0.00	0.12	Powdercoat1		
116	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC3		
130	Packaging	10 pcs	5/18/18	5/18/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea	5/18/18	5/18/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2
Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

11 138889 START: 7:30 OUT: 3:00 FINISH: 8:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	2.9000 ft (.29 ea)	90-Start up Operation	S069913

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	3	13	0

Add 6 Hours



Container No: S090394



Part: D4776-1

Job No: 176792

Serial No/Batch: S090394

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/10/18

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
- 1	Basket Strut Clevis 2.880	0.880Inches ± 0.030	0.910 0.850		
- 2	Basket Strut Clevis .438	0.438Inches ± 0.010	0.448 0.428		
- 3	Basket Strut Clevis 0.380	0.380Inches ± 0.030	0.410 0.350		
- 4	Basket Strut Clevis 0.625	0.625Inches ± 0.010	0.635 0.615		
- 5	Basket Strut Clevis 1.754	1.750Inches ± 0.030	1.780 1.720		
- 6	Basket Strut Clevis 3.500	3.500Inches ± 0.030	3.530 3.470		
- 7	Basket Strut Clevis 45°	45.000Degrees ± 0.500	45.500 44.500	Angle	
- 8	Basket Strut Clevis 0.030	0.030Inches ± 0.030	0.060 0.000		
- 9	Basket Strut Clevis 0.060	0.060Inches ± 0.030	0.090 0.030	Radius	
- 10	Basket Strut Clevis 0.199	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter	
- 11	Basket Strut Clevis 0.264	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter	
- 12	Basket Strut Clevis 0.41	0.410Inches ± 0.030	0.440 0.380	Radius	
- 13	Basket Strut Clevis 1.130	1.130Inches ± 0.030	1.160 1.100		
- 14	Basket Strut Clevis 0.188	0.188Inches ± 0.010	0.198 0.178		
- 15	Basket Strut Clevis 0.190	0.190Inches ± 0.030	0.220 0.160		
- 16	Basket Strut Clevis 0.500	0.500Inches ± 0.030	0.530 0.470		
- 17	Basket Strut Clevis 0.750	0.750Inches ± 0.010	0.760 0.740		
- 18	Basket Strut Clevis 0.400	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter	
- 19	Basket Strut Clevis 0.130	0.130Inches ± 0.030	0.160 0.100	Radius	
- 20	Basket Strut Clevis 0.754	0.750Inches + 0.010 - 0.000	0.760 0.750		
- 21	Basket Strut Clevis 0.160	0.160Inches ± 0.030	0.190 0.130		
- 22	Basket Strut Clevis 45°	45.000Degrees ± 0.500	45.500 44.500	Angle	

Plex 5/1/18 9:15 AM Dart.Gagnon.Michelle